

Work Order ID 66949

Thursday, March 03, 2011 8:47:03 AM



Page 1

Item ID: D3532-1

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 3/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *N* Date: 11-03-3 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3532	Rev A								
100	Hardinge CNC LATHE SMALL	0.00				22			
	Hardinge					22			
	Memo	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA643 & DWG D3532 , <input type="checkbox"/> FOLIO REV: <u> <i>2</i> </u> <input type="checkbox"/> DWG REV: <u> <i>1</i> </u> <input type="checkbox"/> 2-DEBURR AS REQUIRED								
	<i>11/5/19</i>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				22			
	QC					22			
	Memo	0.00							
Quality Control									
	<i>11/5/19</i>								
120	QC8- Inspect parts - second check	0.00				22			
	QC					22			
	Memo	0.00							
Quality Control									
	<i>29 11-5-19</i>								

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66949

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Page 2

Item ID: D3532-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 3/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: C40

0.00



Packaging

Memo

0.00

Packaging

11/5/19 22

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24 28

MF

11-05-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 8:47:09 AM

Page 1

Work Order ID: 66949

Parent Item: D3532-1

Parent Item Name: Spacer



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-07-12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDELNR0.750

Purchased

No

f

61.8400

0.6



Delrin Round Bar 0.75"

Location

Loc Qty

Loc Code

MAT

13.384

116183

13.384

MAT050

48.456

112418

0.12

015472

48.336

~~SD 11/3/23~~

~~1 Rod makes~~

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

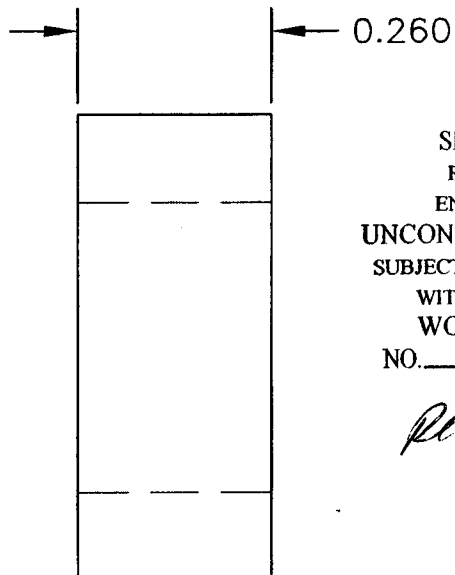
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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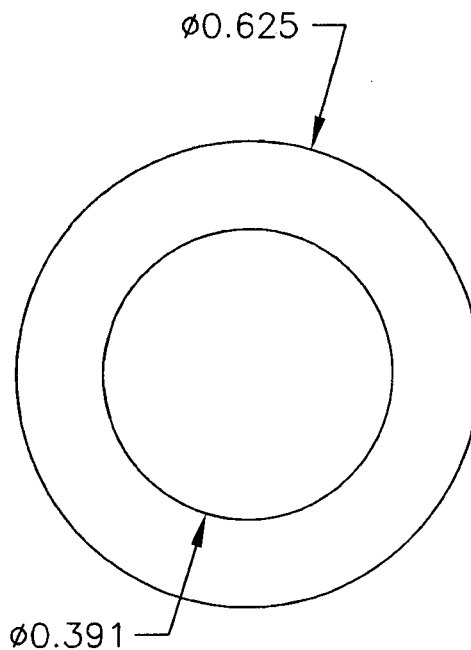
NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3532	REV. A SHEET 1 OF 1
DATE 06.06.26		TITLE SPACER	SCALE 4:1
A	06.06.26	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *46949*
PH-03-3



D3532-1 SPACER

D3532-1 SPACER

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
06-06-26

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W/O:		WORK ORDER CHANGES						
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